

### **LISTING OF CLAIMS:**

Claim 1 (not amended): A process for casting and curing sand cores, in which a core box remains in a fixed vertical plane during core formation, said casting and curing further comprising:

- filling a movable blow head with sand;
- moving the blow head away from the sand hopper towards the core box;
- positioning the blow head in line with a blow valve;
- filling the core box with sand from the blow head, wherein the filling includes applying air pressure to the core box through a blow valve and retracting the blow head.

Claim 2 (currently amended). A process as defined in Claim 1, and including the removal of excess sand from core cavity of the core box by introducing a vacuum manifold and returning the unused vacuumed sand to the sand hopper for use in the next cycle.

Claim 3 (currently amended). A process as defined in Claim 2, and including the application of heat to the sand core by introducing an upper burner manifold.

Claim 4 (currently amended). A process as defined in Claim 3, and including elevation of the cope and core of the core box away from the drag of the core box.

Claim 5 (currently amended). A process as defined in Claim 4, and transferring the cope and core to a core unloader table, by lowering the cope and core onto the loader transfer arms and laterally translating the cope and core to the core unloader table.

Claim 6 (currently amended). A process as defined in Claim 5, and including removal of the core from the cope onto the core unloader table.